



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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PRELIMINARY ISSUE

650.9511

Job Sheet 211107



Part No: 650.9511

Job Qty: 5 pcs

Part Name: Main Seal Poppet



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/6/20

Job Tracking No:

Created By: Jennifer Renwick

Due Date: 7/17/20

Description:

Type: SOLD

Note: 650.9500 REV.PNC2 IPP REV:A 20.06.23 NEW ISSUE DD VERF:JFS

Ship Via:

139 Valve

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	SL-154 - 1	5 pcs	7/17/20		1.00	1.25	Doosan - 1		JB 20.07.25
							NLX 2500SY - 1		
							SL-154 - 1		
							SL-2500Y - 1		
110	QC 2	5 pcs	7/17/20		0.00	0.00	QC 2 - 1		JB 20.07.25
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		



Container No: S290135



Part: 650.9511

Job No: 211107

Serial No/Batch: S290135

Revision: REV.PNC2

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 07/26/20

Plex 7/6/20 11:18 AM Dart.Renwick.Jennifer

DAS
62
9-89

DAS
62
9-89

130

130/191

120 QC 8	5 pcs	7/17/20	0.00 0.00	QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
				QC 2 - 86	
				QC 2 - 83	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
160 Packaging 3-1 - Stock - B4B 5pcs		7/17/20	0.00 0.00	QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
				QC 8 - 66	
				QC 8 - 73	
				QC 8 - 82	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	

20/07/29

DAS
28
9-89

7/6/2020

[Dart Hawkesbury] Job Sheet - Renwick, Jennifer

			Packaging 3 - 20 - B4B	
			Packaging 3 - 21 - B4B	
			Packaging 3 - 22 - B4B	
			Packaging 3 - 23 - B4B	
			Packaging 3 - 24 - B4B	
			Packaging 3 - 25 - B4B	
			Packaging 3 - 26 - B4B	
			Packaging 3 - 37 - B4B	
170 QC 21 - SA	5 pcs	7/17/20	0.00 0.00	QC 21 - SA - 21 QC 21 - SA - 70 QC 21 - SA - 9

Part Op **100** - ***CRITICAL PART - EXTREME CARE MUST BE TAKEN*** 1-Machine as per folio FD317 FOLIO REV:
 Descriptions: AA DWG REV: PN/CL 2-Debur
 110 - QC2- Inspect parts off machine FAI/FAIB
 120 - QC8- Inspect parts - second check
 160 - Identify as per dwg & Stock
 170 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MPEEKR0.625-BE	PEEK Round Bar	.3700 ft (.074 ea)	100-SL-154 - 1	<u>5286794</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-SL-154 - 1	MPEEKR0.625-BE	0	0 ✓	0

Part Specifications

Specifications could not be found.

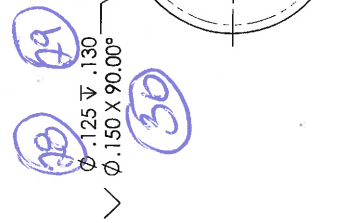
GA
TBD

Plex 7/6/20 11:18 AM Dart.Renwick.Jennifer

6 6 3 4 3



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 211107

[illegible]

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NOTES:

1. MATERIAL: PEEK
2. DEBURR AND BREAK ALL SHARP EDGES
3. IDENTIFY IAW MPP-120
4. FINISH $\sqrt{125}$ MAXIMUM UNLESS OTHERWISE SPECIFIED

PROTOTYPE REVISIONS

ZONE	REV	DESCRIPTION	DATE	APPROVED
A3-2		ADDED 8.005±.015 DIMENSION		
B4-2		DIMENSION 45.00±.01		
C1-2		ADDED 45.00±.01 DIMENSION		
C2-2		ADDED SURFACE ROUGHNESS VALUE		
C6-2		DIMENSION WAS $\phi .500 \pm .001$ IS $\phi .497 \pm .001$ /- .000	06/01/2020	T. CROSS
D4-2		ADDED SURFACE ROUGHNESS VALUE		
		ADDED SURFACE ROUGHNESS VALUE		

8

7

6

4

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: <u>21107</u>		DISPOSITION		DEPARTMENT/PROCESS				Engineering											
Part No. <u>650.9511</u>		Rework ☐ Scrap ☐ Use-as-is ☒		Skid-tube ☐ Machining ☐ Large Fab ☐		Cross tube ☐ Small Fab ☐ Finishing ☐		Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐		Water Jet ☐ Supplier ☐ Quality ☐									
Date: <u>JULY 17, 2020</u>		Sequence #: _____		QTY Affected: <u>6</u>		MRB (QSI042) <u>SM</u>		Completed By <u>JULY 17, 2020</u>		Lead hand / Supervisor <u>20/07/29</u>									
Description Work Order Deviation				Disposition															
650.9511 HAS BEEN MANUFACTURED TO TOLERANCES THAT ARE HAND WRITTEN ON DRAWING 0.497 $\pm$ 0.001 $\Rightarrow$ NOW 0.499 $\pm$ 0.002 -0.000				UPDATED TOLERANCE IS APPROVED															
Root Cause				FAULT CATEGORY															
Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☒ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐								Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐				Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐			
Other/Details:				DRAWING WILL BE UPDATED (RECOMMENDED TOLERANCE FROM THEIR CROSS															

DART AEROSPACE LTD

Work Order:

211107

Description: MAIN SEAL POPPET

Part Number:

650.9511

Inspection Dwg: 650.9500

Rev: PN/C13

Page 1 of 1

INSPECTION SHEET

	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1	R .010	± .005	R .010	✓		RG 1/64	Ref
2	R .025	± .005	R .025	✓		RG 1/32	Ref
3	R .010	± .005	R .010	✓		RG 1/64	Ref
4	R .020	± .005	R .020	✓		RG 1/64	Ref
5	45.0°	± .5°	45.0°	✓		optical comp	
6	R .005	± .005	R .005	✓		RG 1/64	Ref
7	√32	-	31	✓			
8	Ø .499	+ .000 / - .001	.4987	✓		mic	JB-09
9	Ø .107	± .005	.1065	✓		GP .106	Ref
10	.315 ↓	± .005	.316	✓		GP + Vernier	JB-01
11	6-32 UNC - 2B	GO / NO-GO	6-32 UNC 2B	✓		GO / No-GO	6-32 UNC 2B
12	.279 ↓	± .005	.2795	✓		Set screw + vernier	JB-01
13	Ø .157 x 90°	± .005 x .5°	.159 x 90°	✓		vernier	JB-01
14	Ø .295	± .001	.2951	✓		optical comp	
15	.020	± .005	.0216	✓		optical comp.	
16	.121	± .005	.1216	✓		optical comp.	
17	.240	± .005	.2402	✓		optical comp	
18	.415	± .005	.4152	✓		optical comp.	
19	.560	± .005	.5602	✓		optical comp.	
20	.685	± .005	.6852	✓		mic	JB-09
21	√32	-	—	✓		cant measured surface too small	
22	Ø .375	± .001	.3751	✓		Blade Mic	LG-inspb
23	Ø .356	± .001	.3558	✓		Blade Mic	LG-inspb
24	.055	± .002	.0548	✓		optical comp	
25	√32	-	—	✓		cant measured surface too small	
26	√32	-	—	✓		cant measured surface too small	
27	.072	± .002	.0718	✓		optical comp.	
28	Ø .125	± .005	.124	✓		GP .125	Ref
29	.130 ↓	± .005	.132	✓		GP + vernier	JB-01
30	Ø .150 x 90.00°	± .005 x .5°	.150 x 90°	✓		vernier	JB-01

Measured by:

JB 62

Checked by:

ML

QC Inspector:

Date:

20-07-25

Date:

20/07/29

Date:

Engineering Approval:
(If necessary)

Date:

Rev

Date

Change

Revised by

Approved

A

25-Jul-20

New Issue

MG

